

**Amendments to the Specification**

Please replace the paragraphs [0007], [0008] and [0019] with the following rewritten paragraphs:

[0007] Fig. 1 is a ~~photograph~~ computer generated drawing of a section of an ingot of AA 7055 produced in part according to the present invention;

[0008] Fig. 2 is a ~~photograph~~ computer generated drawing of a section of an ingot of AA 2124 (CU82) produced in part according to the present invention;

[0019] A melt of aluminum alloy 7055 of the Aluminum Association (AA) was direct chill cast using an aqueous coolant containing 3 ppm tetrapotassium phosphate during a portion of the casting process. An ingot of alloy AA 2124 was produced in a similar manner. In both instances, the casting was performed using water available in the casting plant as the coolant and was then switched to a coolant containing 3 ppm tetrapotassium pyrophosphate. Figs. 1 and 2 are ~~photographs~~ computer generated drawings of a portion of the ingots produced of alloy 7055 and alloy 2124 (labeled as CU82). In both instances, the ingot exhibits a bright portion and a dark portion. The bright portion was cast when the coolant contained the oxidation inhibitor, and the dark portion of the ingot was produced when the coolant was water alone. The thickness of the oxide layers of the ingots was measured is shown in Fig. 3 for two locations in each of the dark portion and the bright portion of the ingots. In both instances, it is apparent that the oxide layer is significantly thinner in the bright portion of the ingot than in the dark portion of the ingot.

**Amendments to the Drawings**

The attached sheet of computer generated drawings which includes Figs. 1 and 2, replaces the original sheet including Figs. 1 and 2.

Attachment: Replacement Sheet